

Date: Wednesday, 12/13/2006 2:41:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 29922A	
Estimate Number : 10352	
P.O. Number : <u>N/A</u>	Part Number : D2280
This Issue : 12/13/2006 S.O. No. : <u>N/A</u>	Drawing Number : D2280 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 28791A	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 1/5/2007 Qty: 40 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A New Issue 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0250X01000	6061-T6 Bar .25" x 1.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.2975 f(s)/Unit Total : 11.8986 f(s)
 Material: 6061-T6 (QQ-A-250/8) 0.25" Thick
 (M6061T6B0.250x1.000) Identify as D2280
 Batch: M103039

J.F. 06/12/22

(40)

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut blank: (3.400") +/-0.020"

J.F. 06/12/22

(40)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2280 and Dwg D2280

2-Deburr Then Tumble

J.F. 06/12/22

(40)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/22

(40)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.G. 06/12/22

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/02

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:41:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 29922A

Part Number: D2280

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mm *PR/YD* *06/12/28*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mm *06 12 28* *(40)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SL35*

EP 06/12/29 (40) *PUR 01/2*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(38) *05/01/02*

Job Completion



CL 07/01/02

Dart Aerospace Ltd

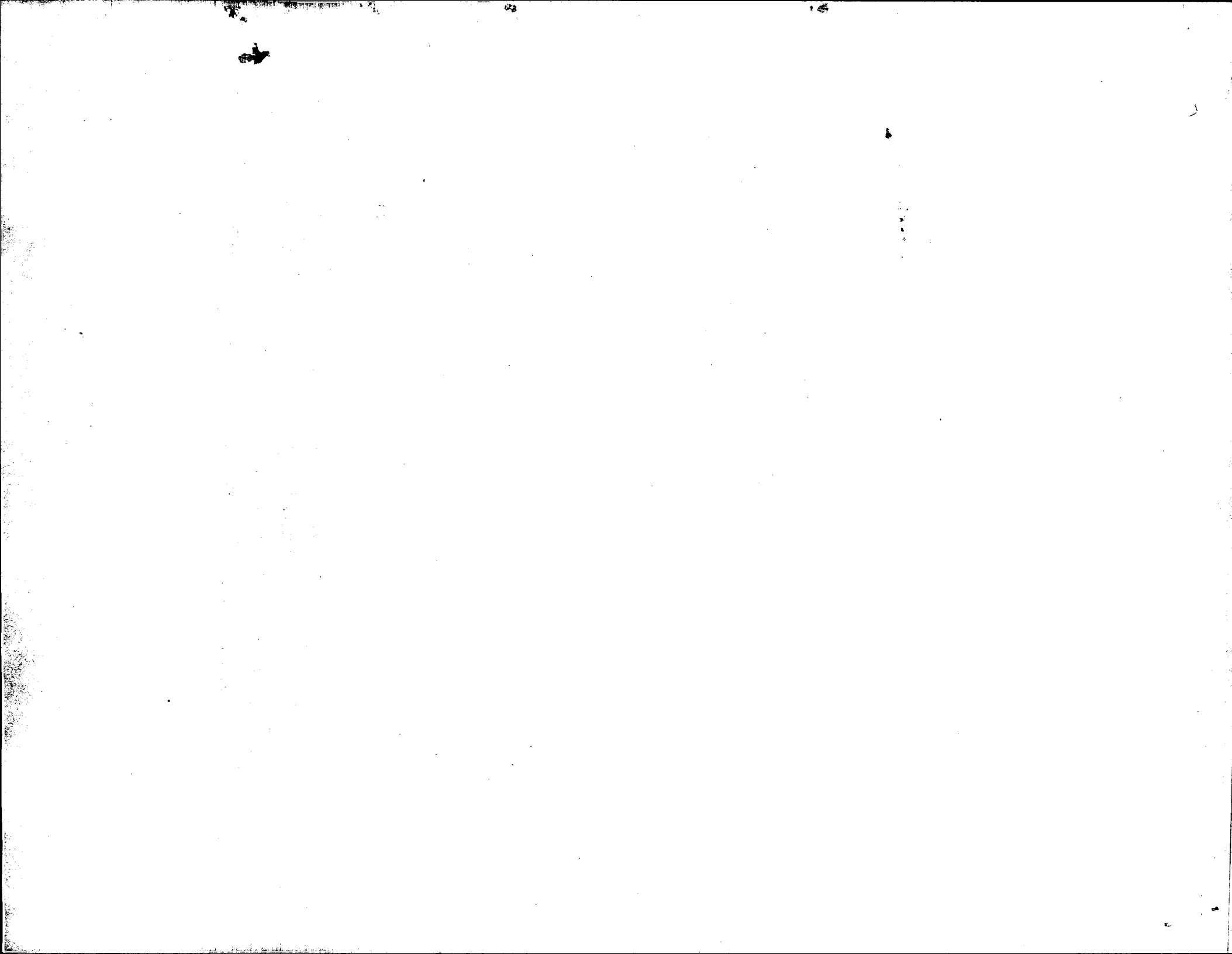
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

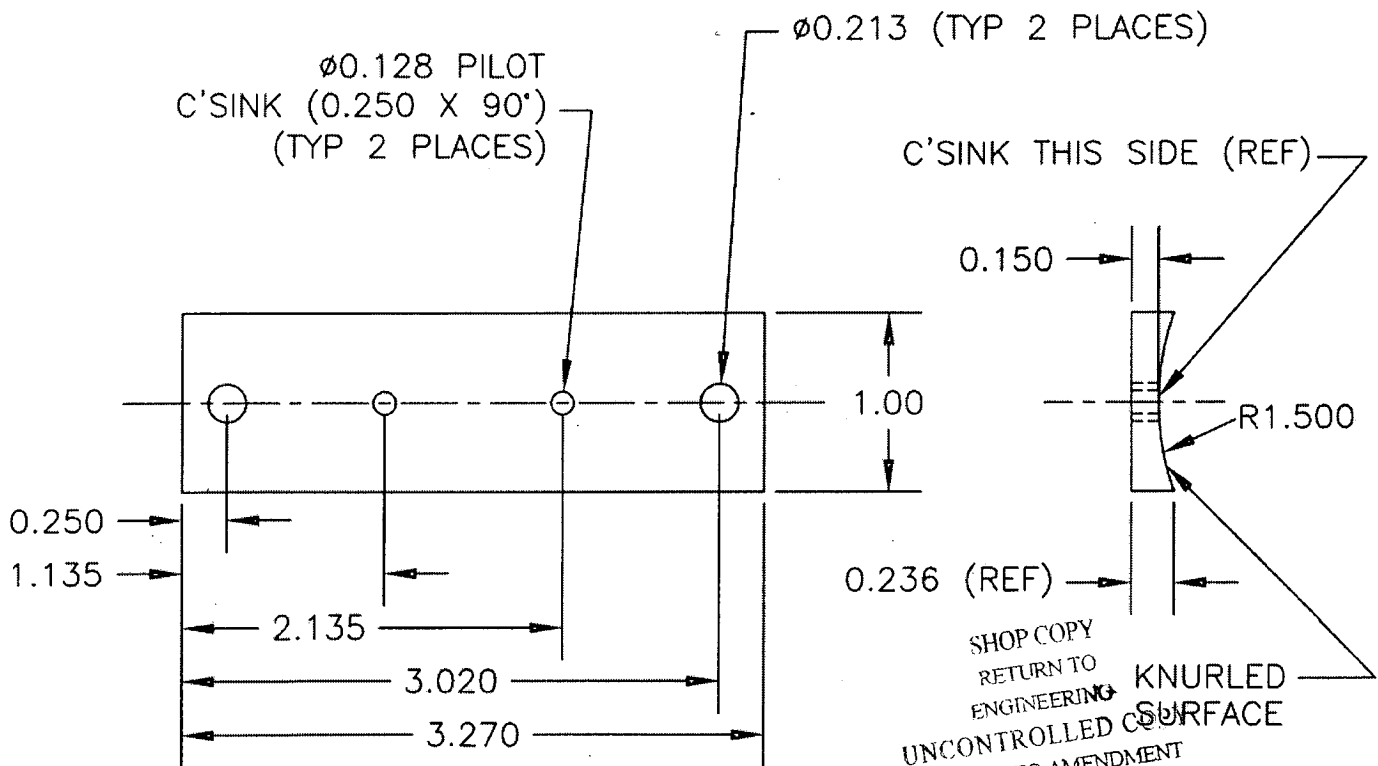
NOTE: Date & initial all entries





DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2280	REV. D SHEET 1 OF 1
DATE 05.11.14		TITLE SPACER	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
D	05.11.14	ADD FINISHING NOTE	

RELEASED
05.11.28



D2280 SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000 (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.